

Date: Monday, 29/09/2008 11:54:49 AM  
 User: Julie Lecocq

*SPLIT*

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	MOUNTING LUG		
Job Number	42316			Part Number	D22303		
Estimate Number	10256			Drawing Number	D2230 REV F		
P.O. Number				Project Number	N/A		
This Issue	29/09/2008	S.O. No.	:	Drawing Revision	F		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	10/10/2008	Qty:	200
Previous Run	41334			Um:	Each		
Written By							
Checked & Approved By	JUL 08.9.29						
Comment	Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
Comment:	Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)	
	Lug Extrusion	
	D2423	
	Batch: B39513 43722	
2.0	BAND SAW	BAND SAW
Comment:	Band Saw	
	Cut D2423 extrusion to 0.82"	
	Batch: B39513 43722	<i>cut @ metec</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment:	HAAS CNC VERTICAL MACHINING #1	
	Machine per folio D2230-3 ←	
	Check for crack while loading into the machine.	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment:	Receive + Inspect for transit damage Ensure C97C attached	
5.0	QC5	SECOND CHECK
Comment:	SECOND CHECK	
	Inspect Level 5	



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 42316

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



M-A S 8/12/11

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



100X

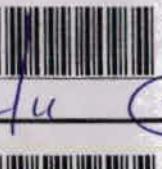
Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-A 08/12/11

8.0 QC5

INSPECT WORK TO CURRENT STEP



route  
x100  
100X

Comment: INSPECT WORK TO CURRENT STEP

S 68/12/11 x100

9.0 POWDER COATING

POWDER COATING



100X

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 1=10

320°F

OVEN TEMPERATURE: 320°F

FINISH TIME: 1=50

m-a 08/12/11

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

08-12-11 x100

11.0 PACKAGING 1

PACKAGING RESOURCE #1



100X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 410

8/12/11

SD

12.0 QC21

FINAL INSPECTION/W/O RELEASE



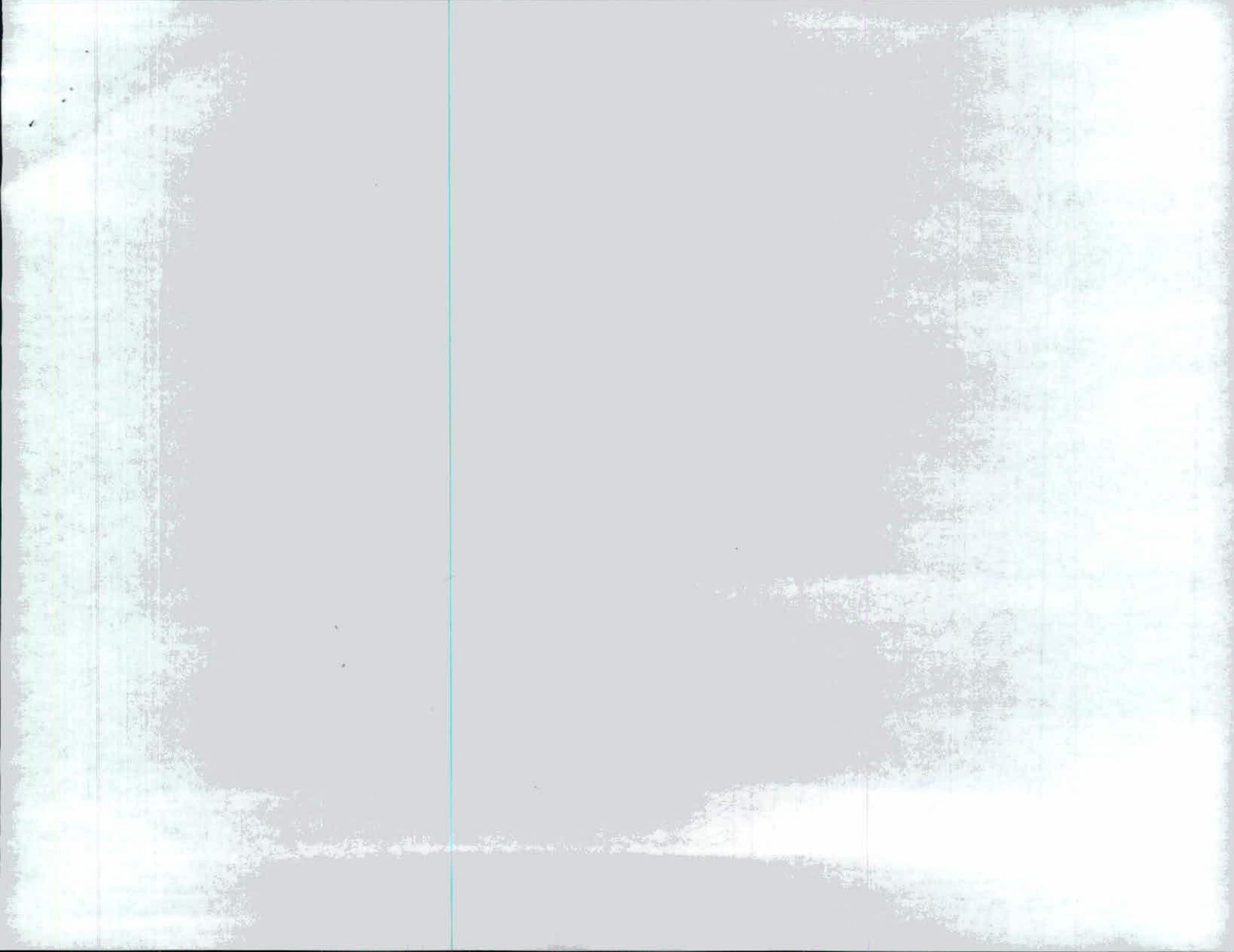
08/12/12 41

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-11



DART AEROSPACE LTD	Work Order:	42310
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

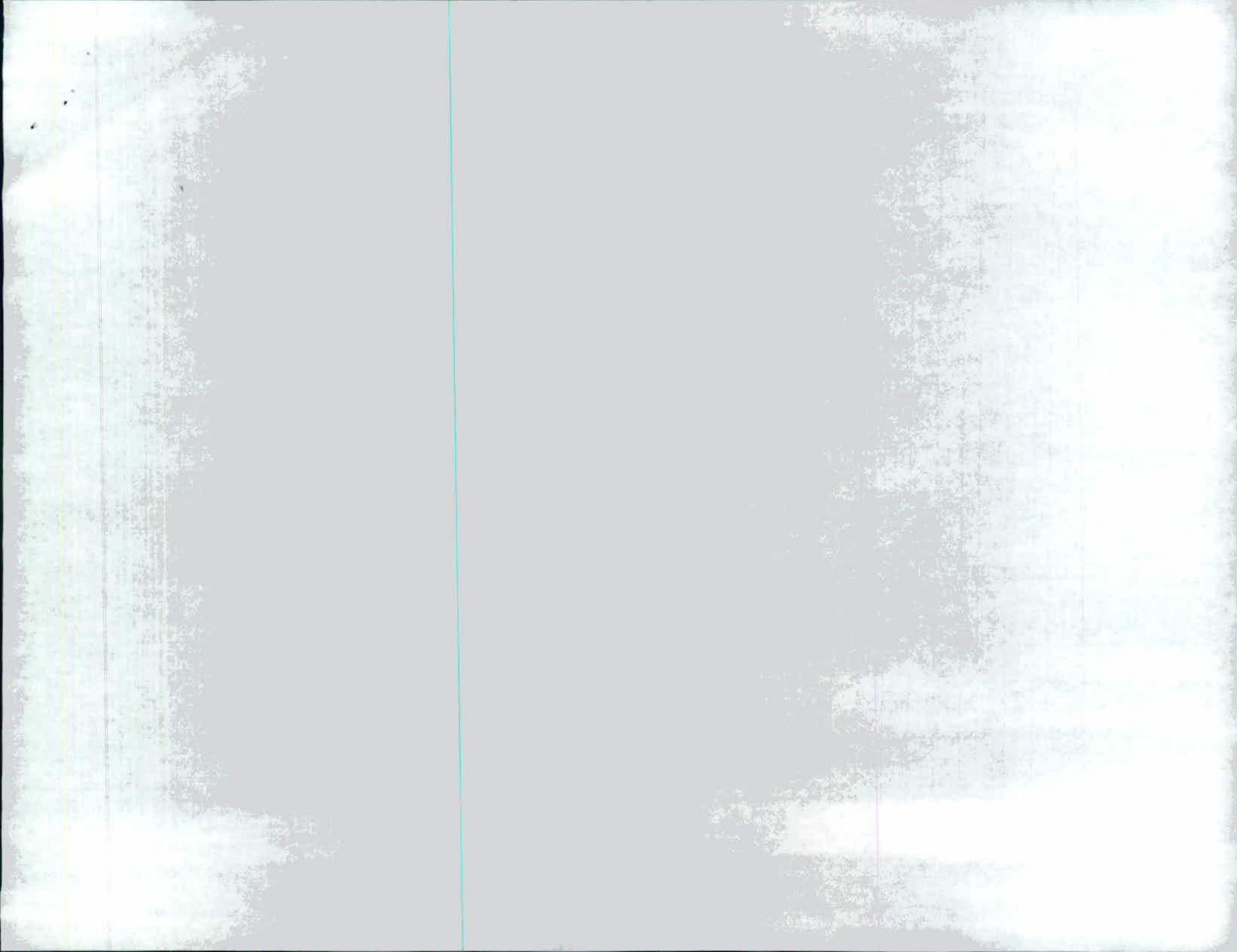
## FIRST ARTICLE INSPECTION CHECKLIST

## First Article    Prototype

N/A

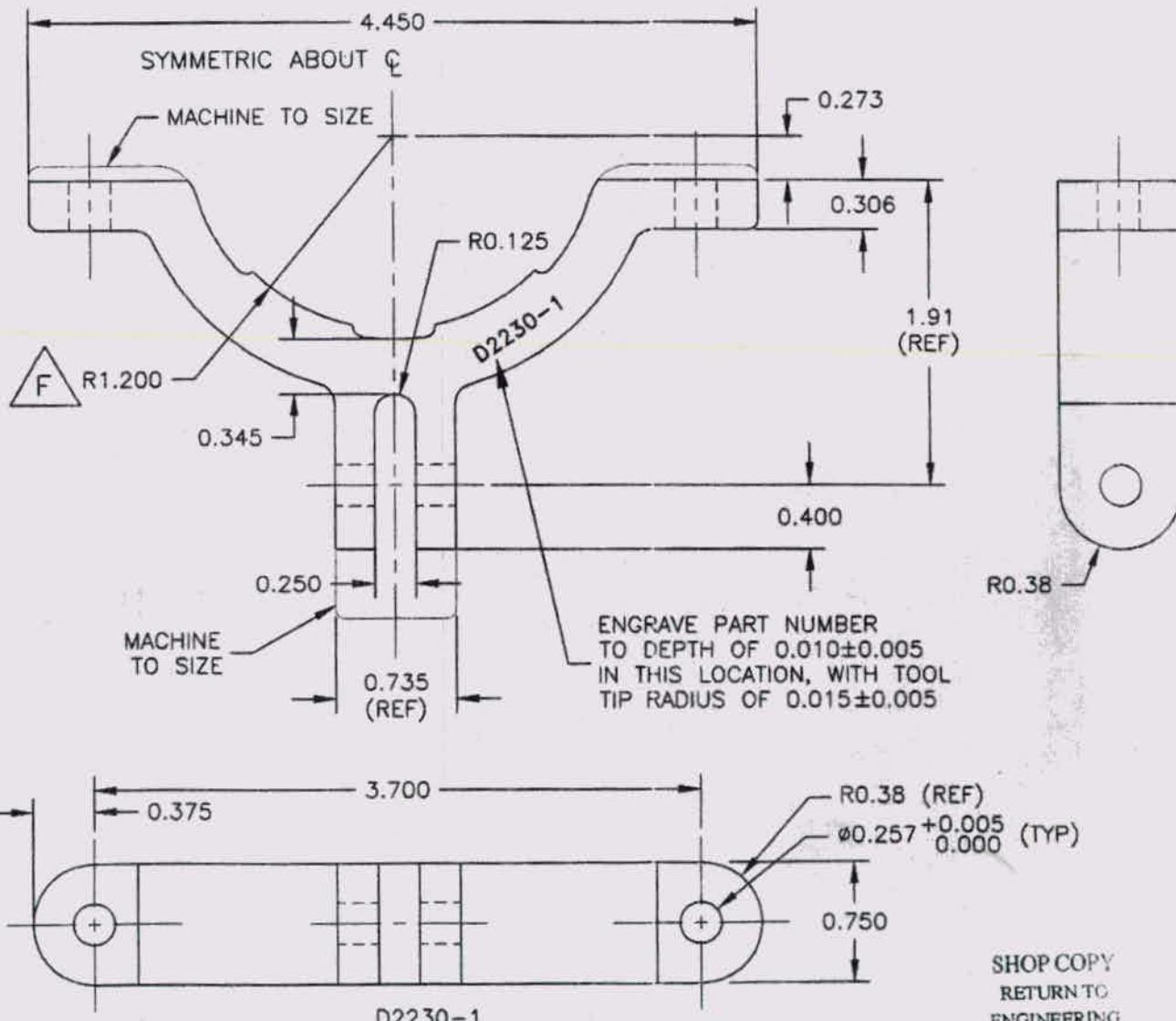
<b>Measured by:</b>	<b>Audited by:</b>	<b>Prototype Approval:</b>	N/A
Date:	Date:	Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	FF



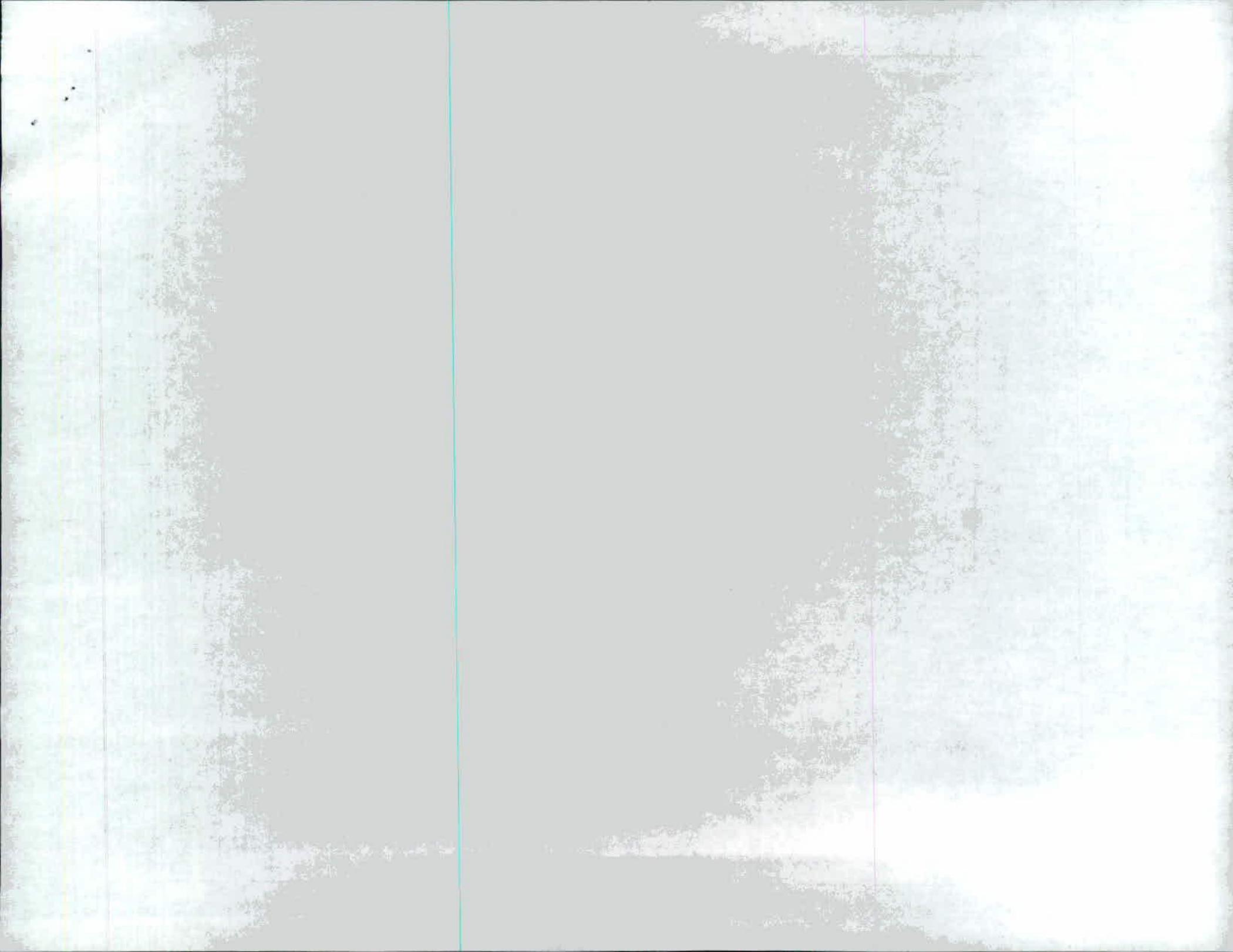
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE		TITLE MOUNTING LUG SCALE 1:1
99.12.13		
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED  
99.12.21 DS

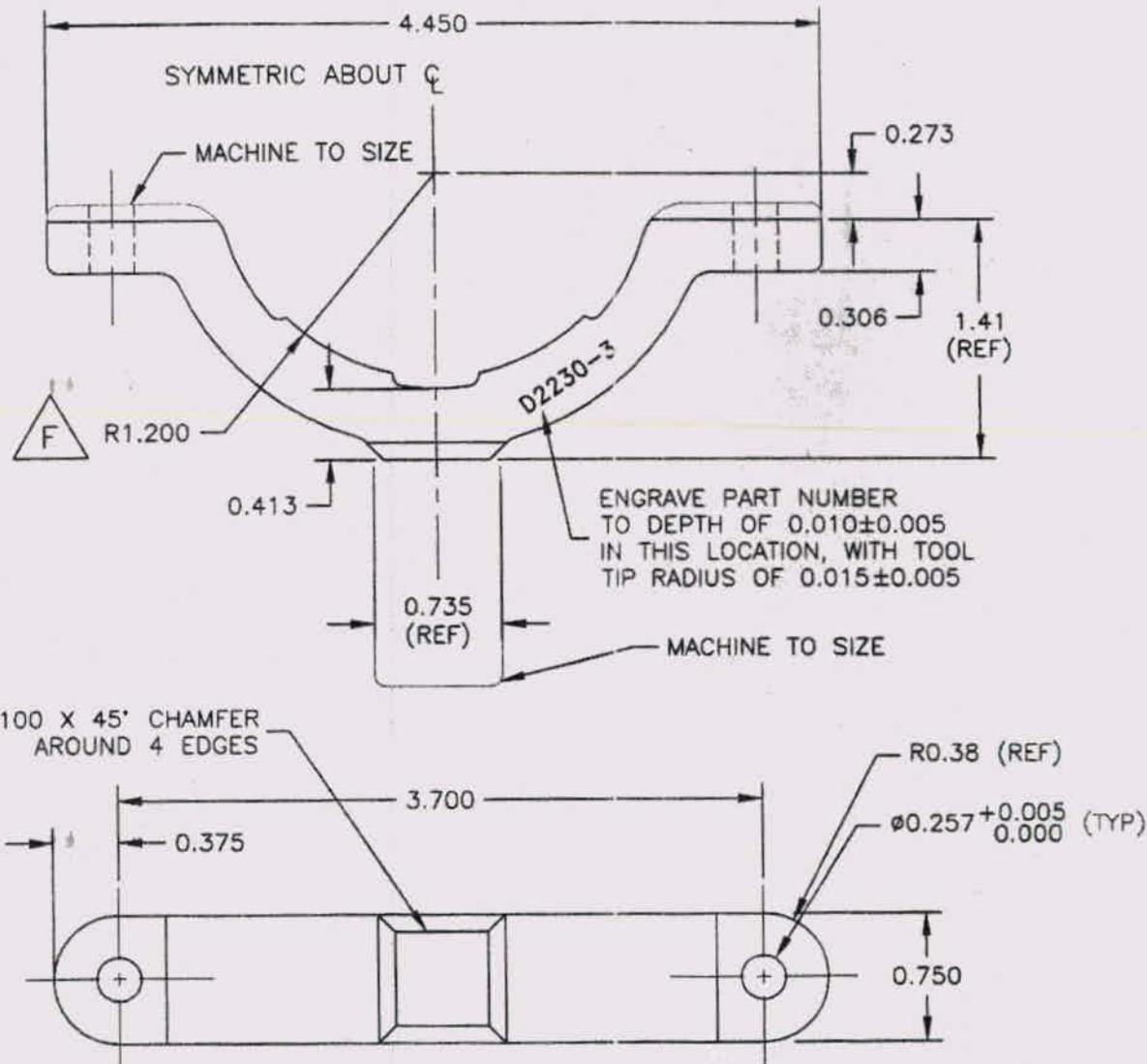
MAKE FROM EXTRUSION D2423  
 BREAK ALL EDGES 0.000-0.015  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 92316



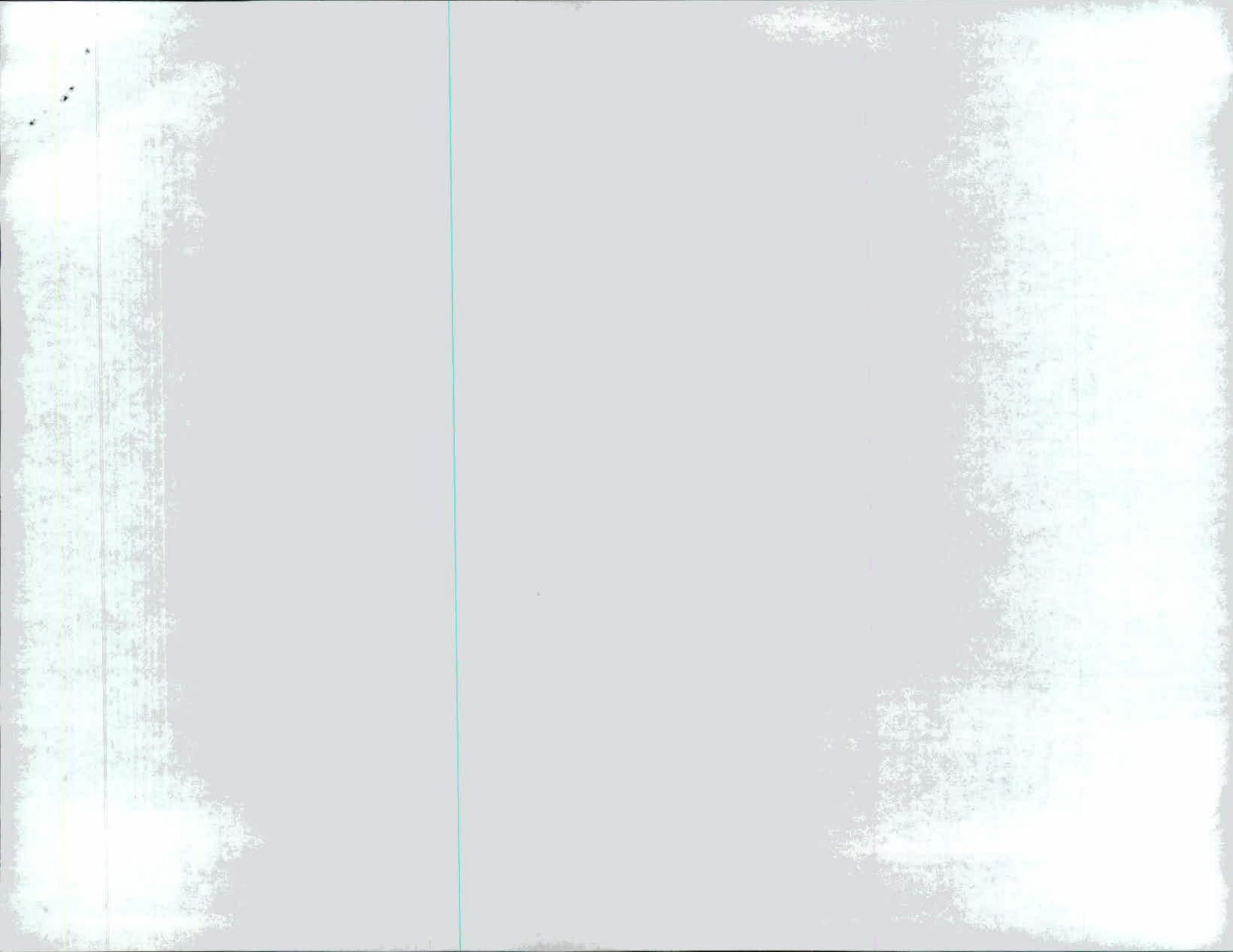
**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2230
DATE	99.12.13			REV. F SHEET 2 OF 2 SCALE 1:1

**RELEASED**  
*99.12.21 DS*

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44230





## CERTIFICATE OF CONFORMITY

**SOLD TO:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2230-3	Lug	7300

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz".  
Shigi Walz

Vankleek Hill, December 11, 2008

1950-1951

1951